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Eickhoff et al.

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(54) **HYBRID FUEL CELL**

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(51) **Int. Cl.**

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H01M 8/06 (2006.01)

H01M 16/00 (2006.01)

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CPC **H01M 8/04089** (2013.01); **C01B 3/065** (2013.01); **C01B 3/10** (2013.01); **H01M 8/065** (2013.01); **H01M 16/006** (2013.01); **C01B 2203/066** (2013.01); **H01M 8/04067** (2013.01); **H01M 8/04208** (2013.01); **H01M 8/04216** (2013.01); **H01M 8/04701** (2013.01); **H01M 8/04828** (2013.01); **H01M 10/0525** (2013.01); **Y02E 60/362** (2013.01); **Y02E 60/50** (2013.01)

(58) **Field of Classification Search**

None

See application file for complete search history.

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Primary Examiner — Alix Eggerding

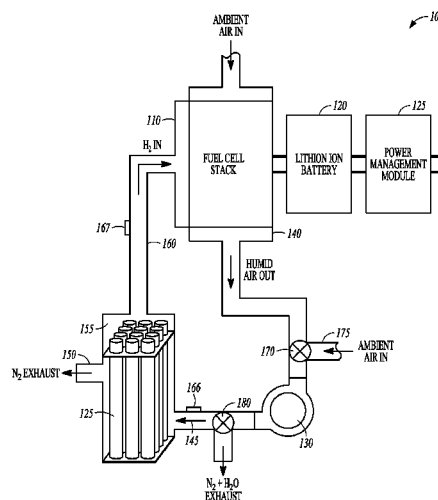
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(57)

ABSTRACT

A power generator includes a chemical hydride multilayer fuel cell stack. A flow path extends through the fuel cell stack to provide oxygen containing air to the fuel cell stack and to cool the fuel cell stack. A hydrogen generator is coupled to the flow path to receive water vapor from ambient air introduced into the flow path and water vapor generated by the fuel cell stack and to provide hydrogen to the fuel cell stack. A controller separately controls airflow past the fuel cell stack and water vapor provided to the hydrogen generator.

16 Claims, 12 Drawing Sheets



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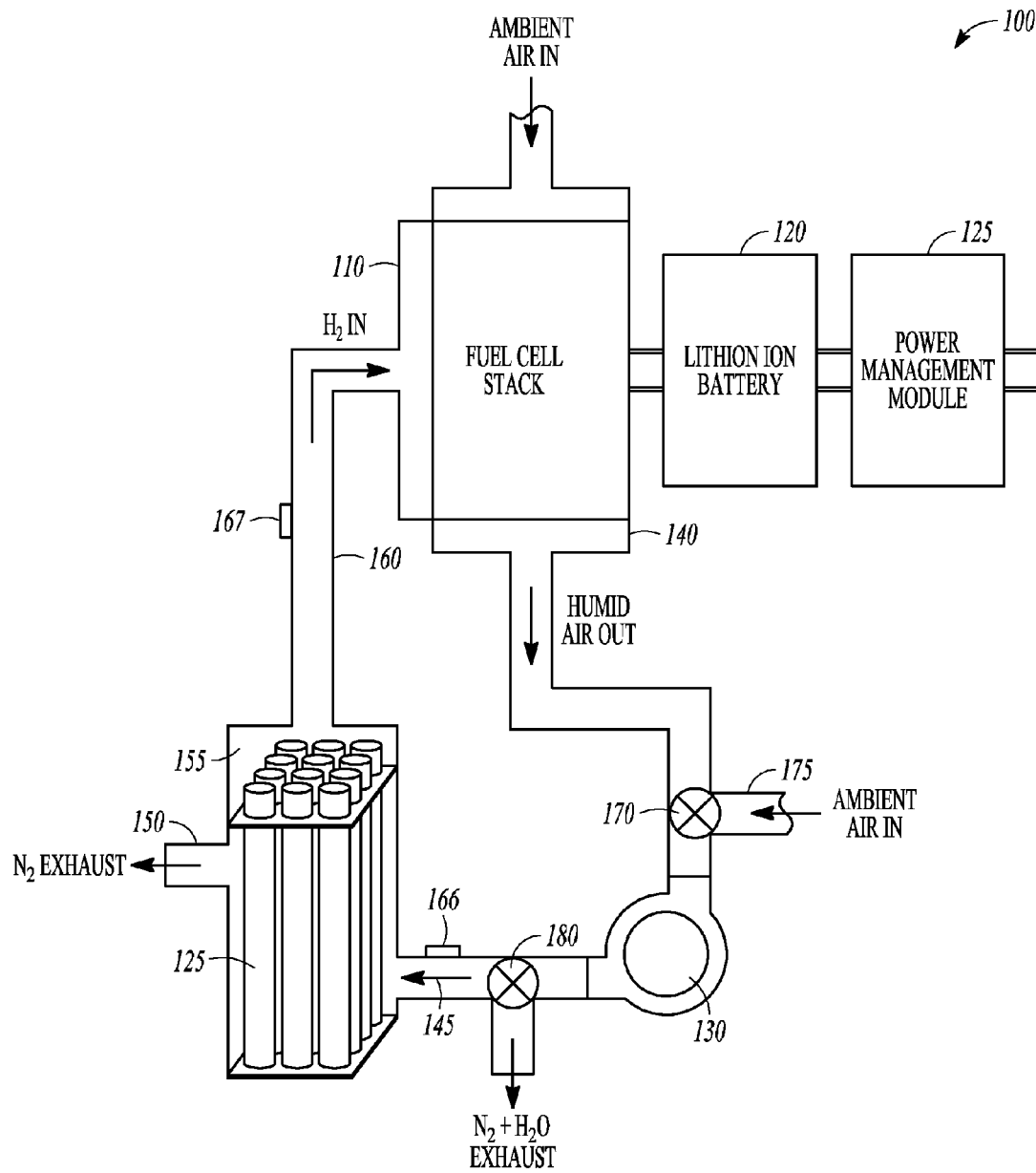
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**FIG. 1**

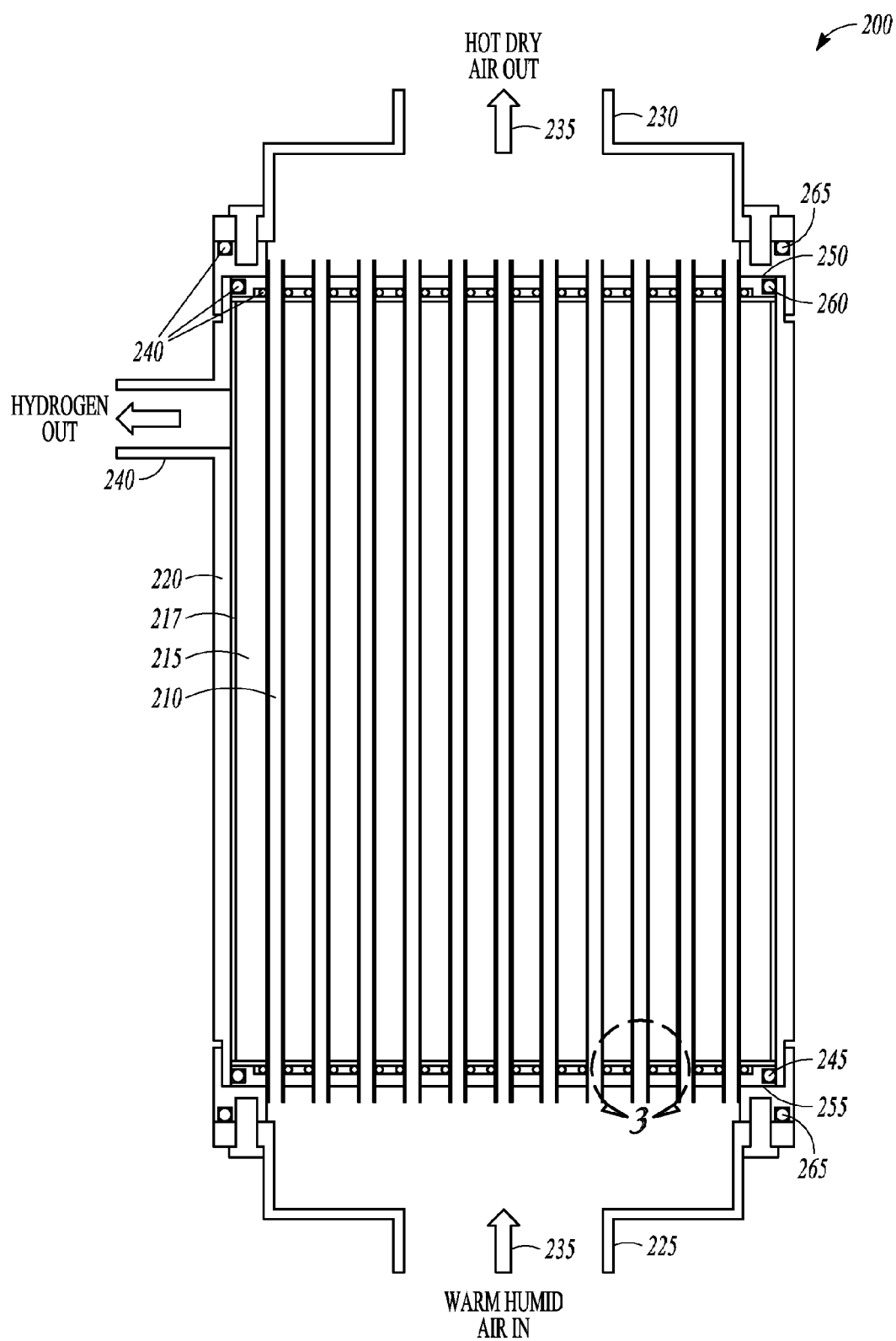


FIG. 2

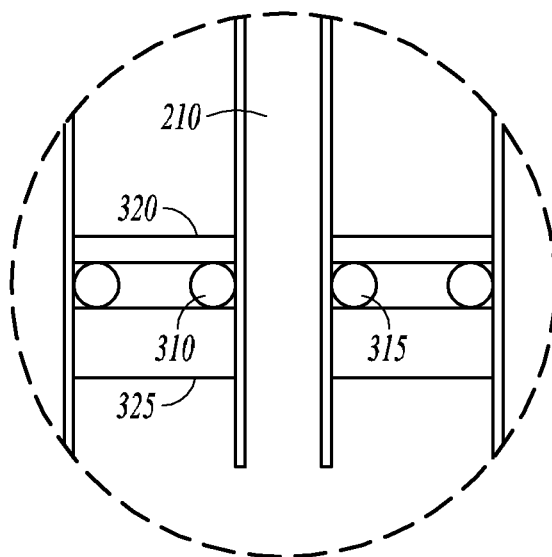


FIG. 3

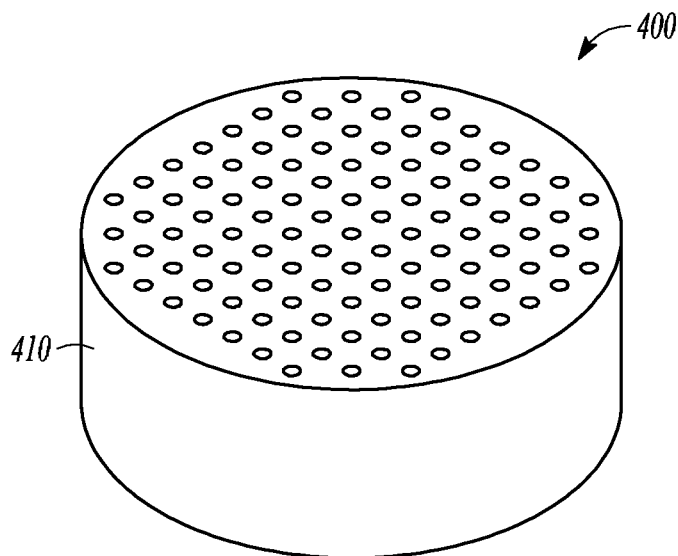


FIG. 4

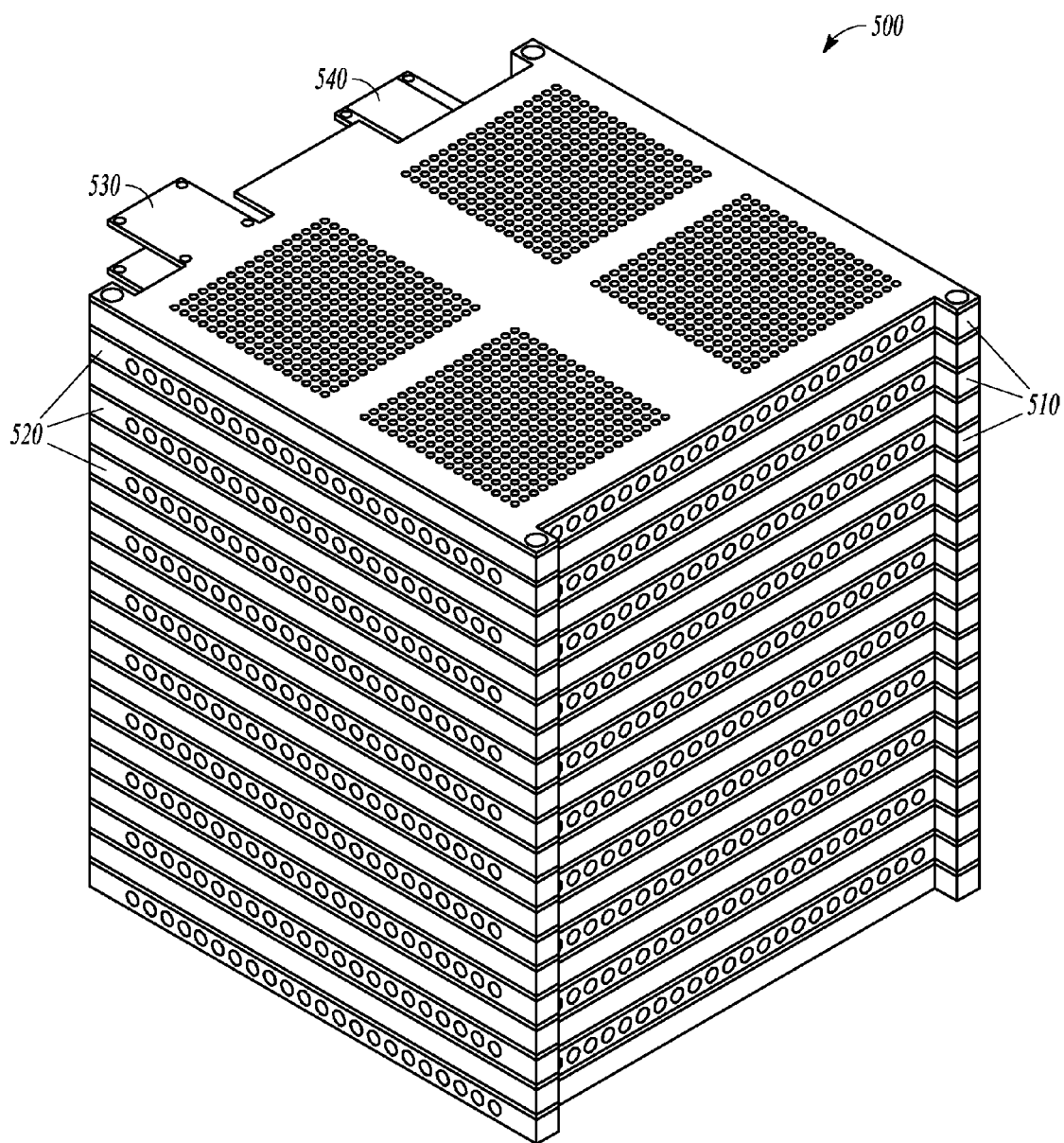


FIG. 5A

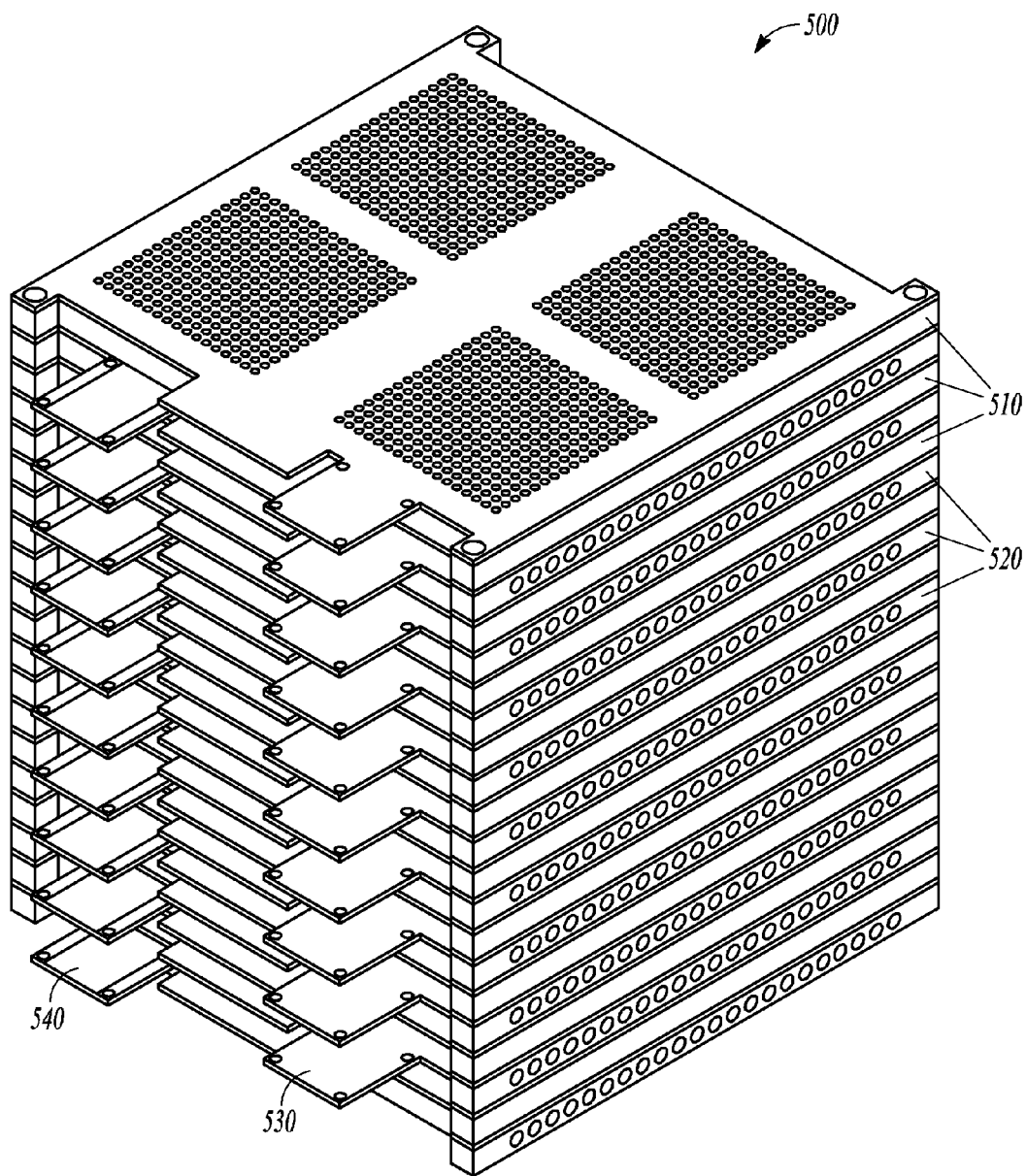


FIG. 5B

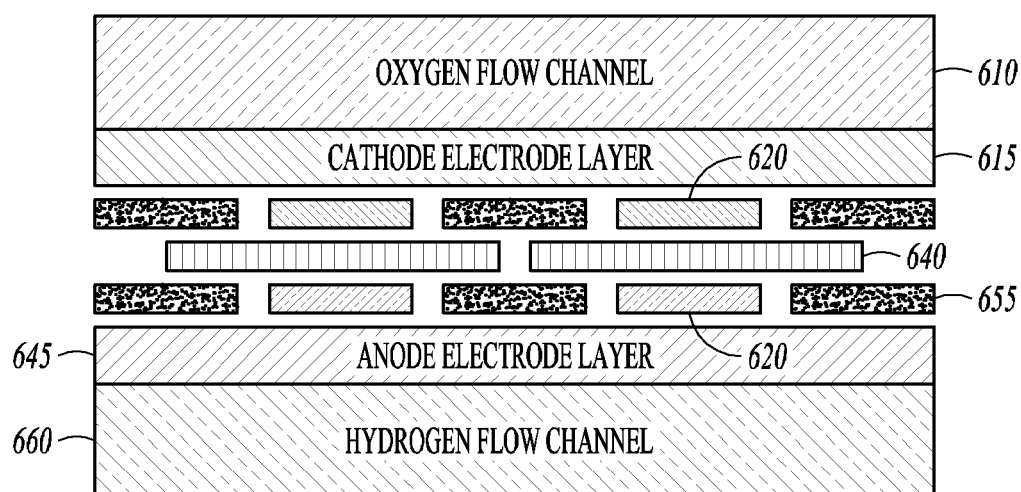


FIG. 6

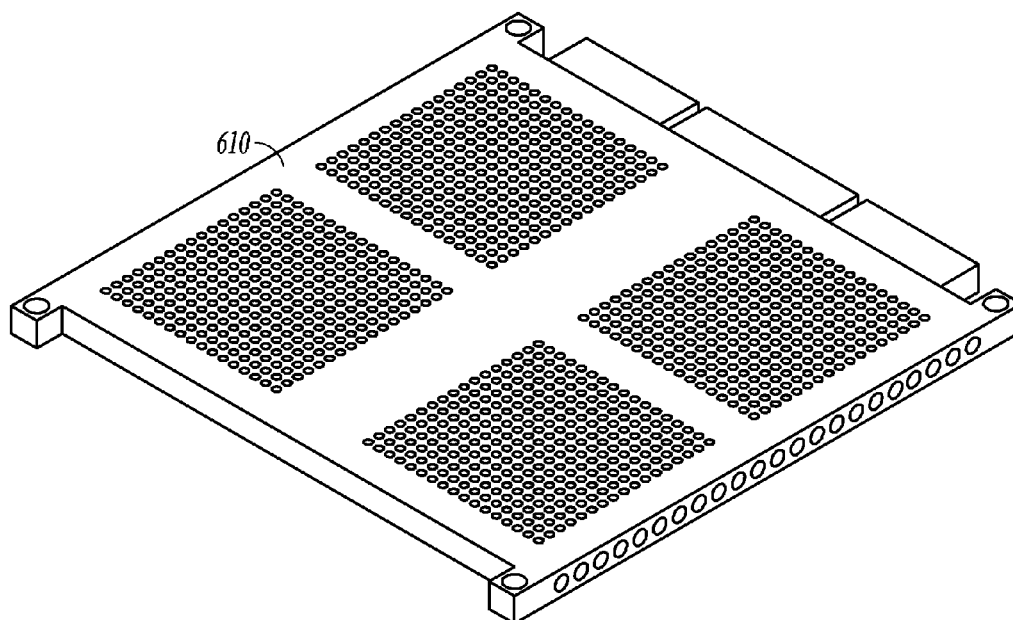


FIG. 7

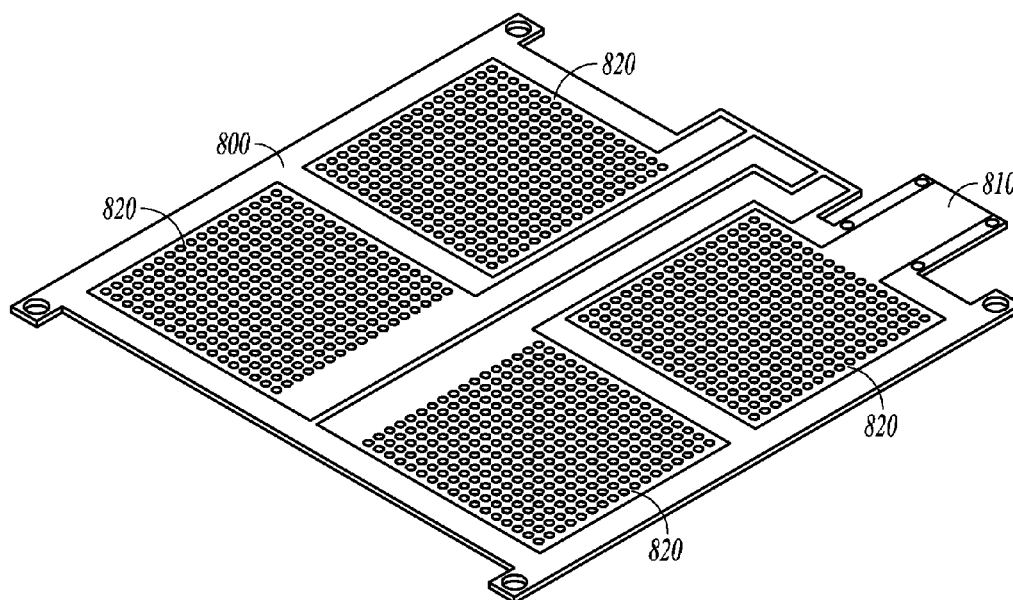


FIG. 8

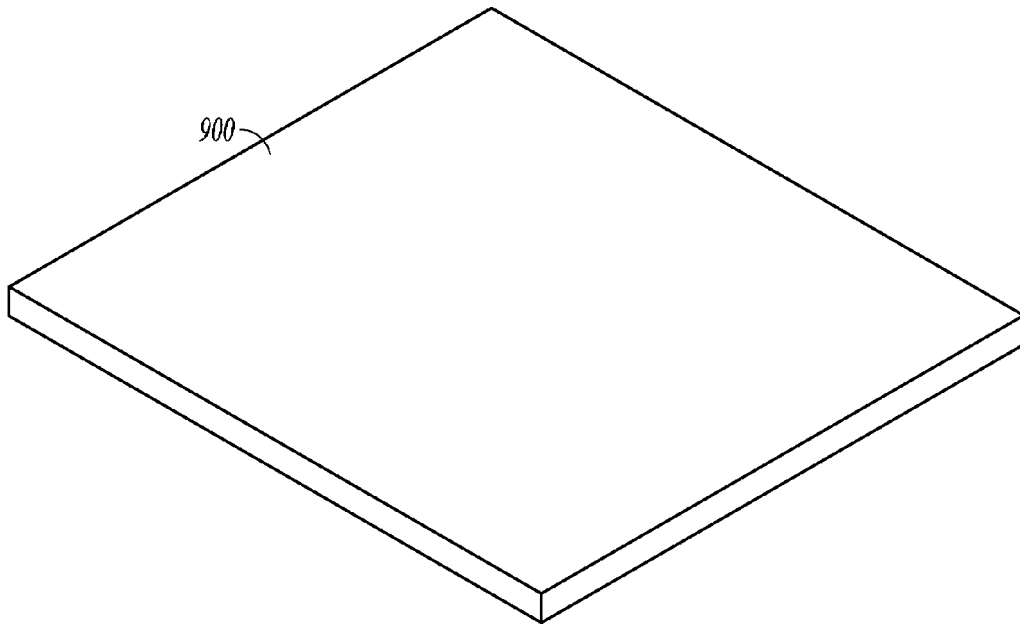


FIG. 9

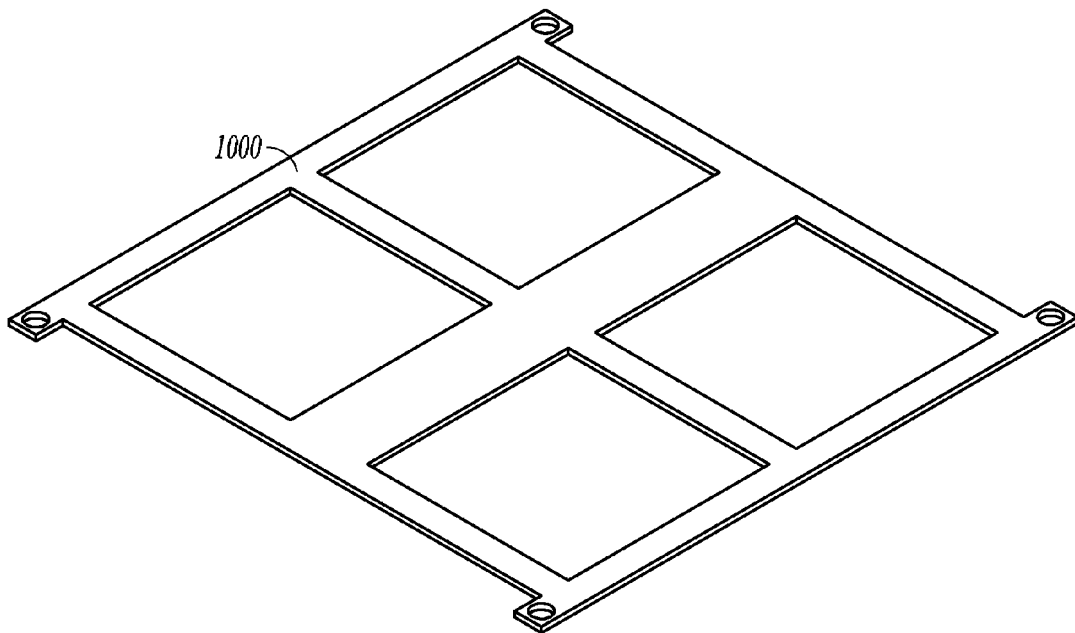


FIG. 10

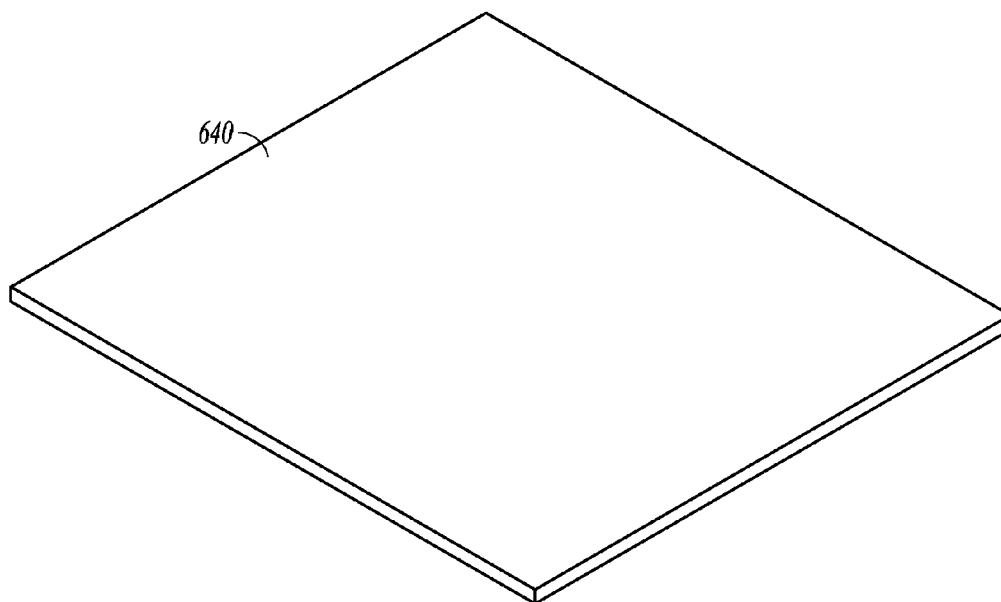


FIG. 11

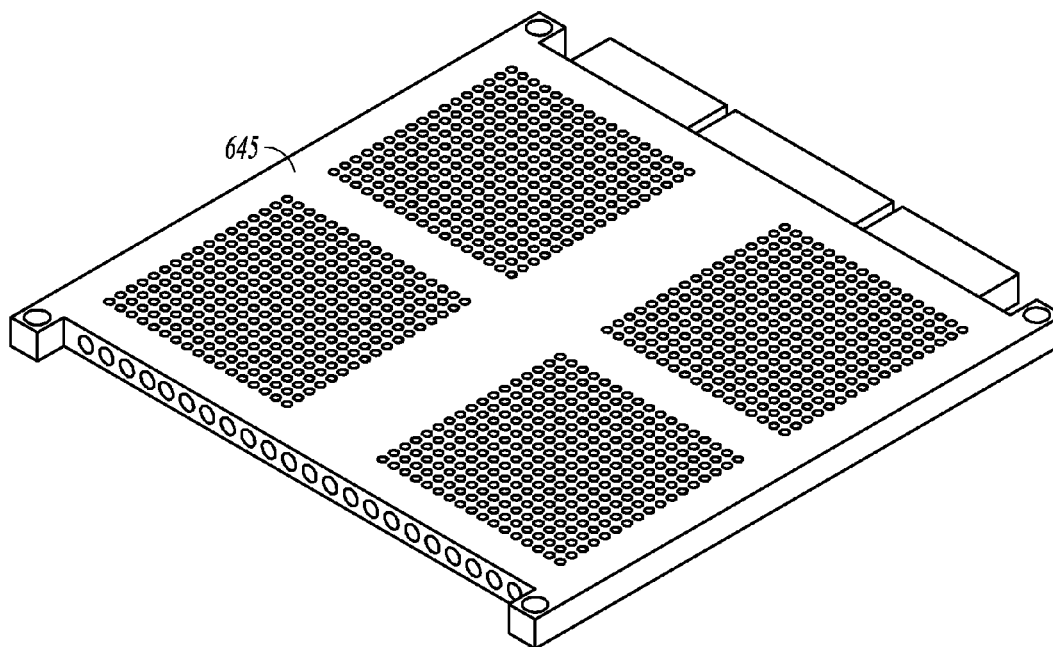


FIG. 12

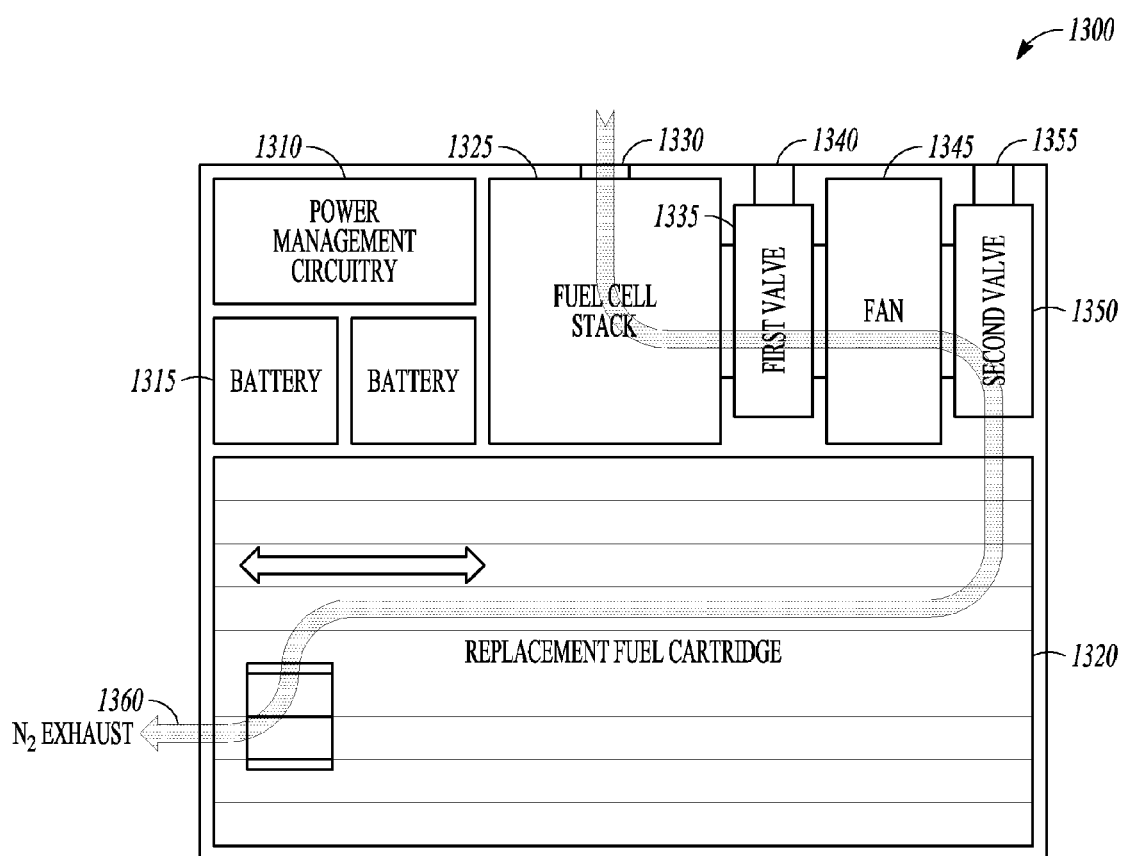


FIG. 13

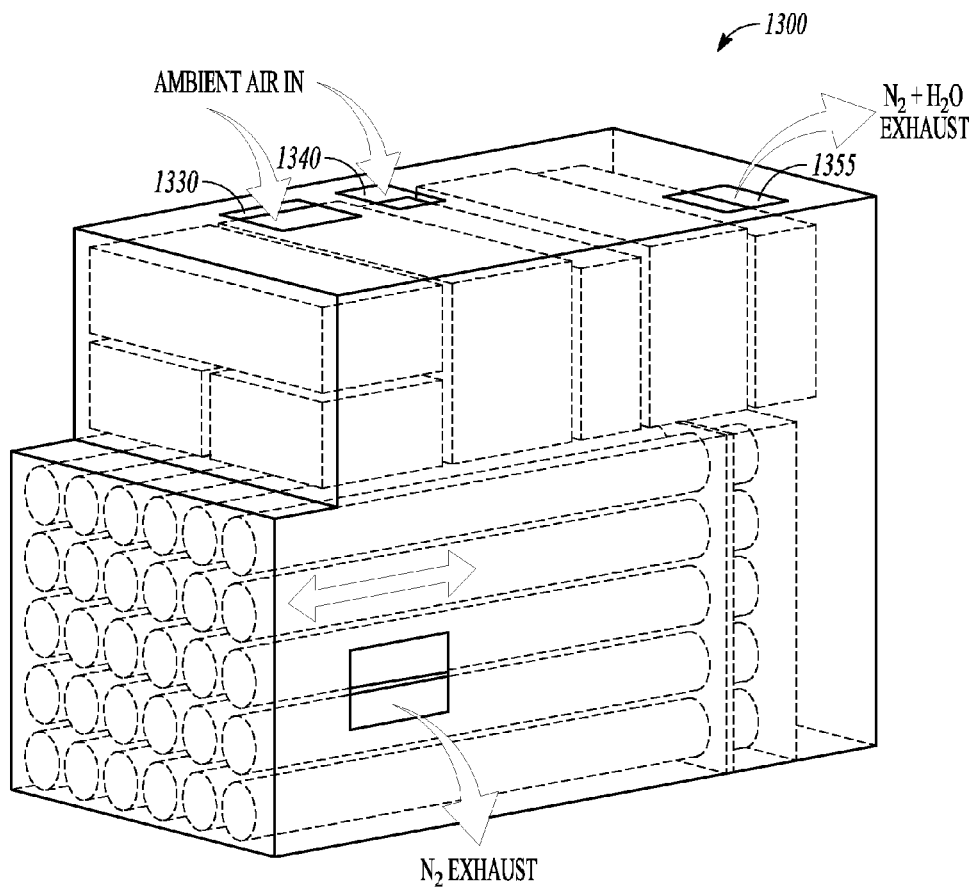


FIG. 14

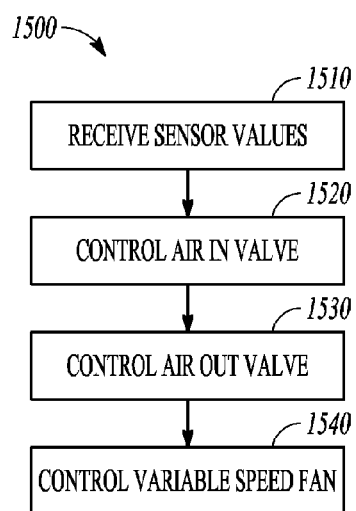


FIG. 15

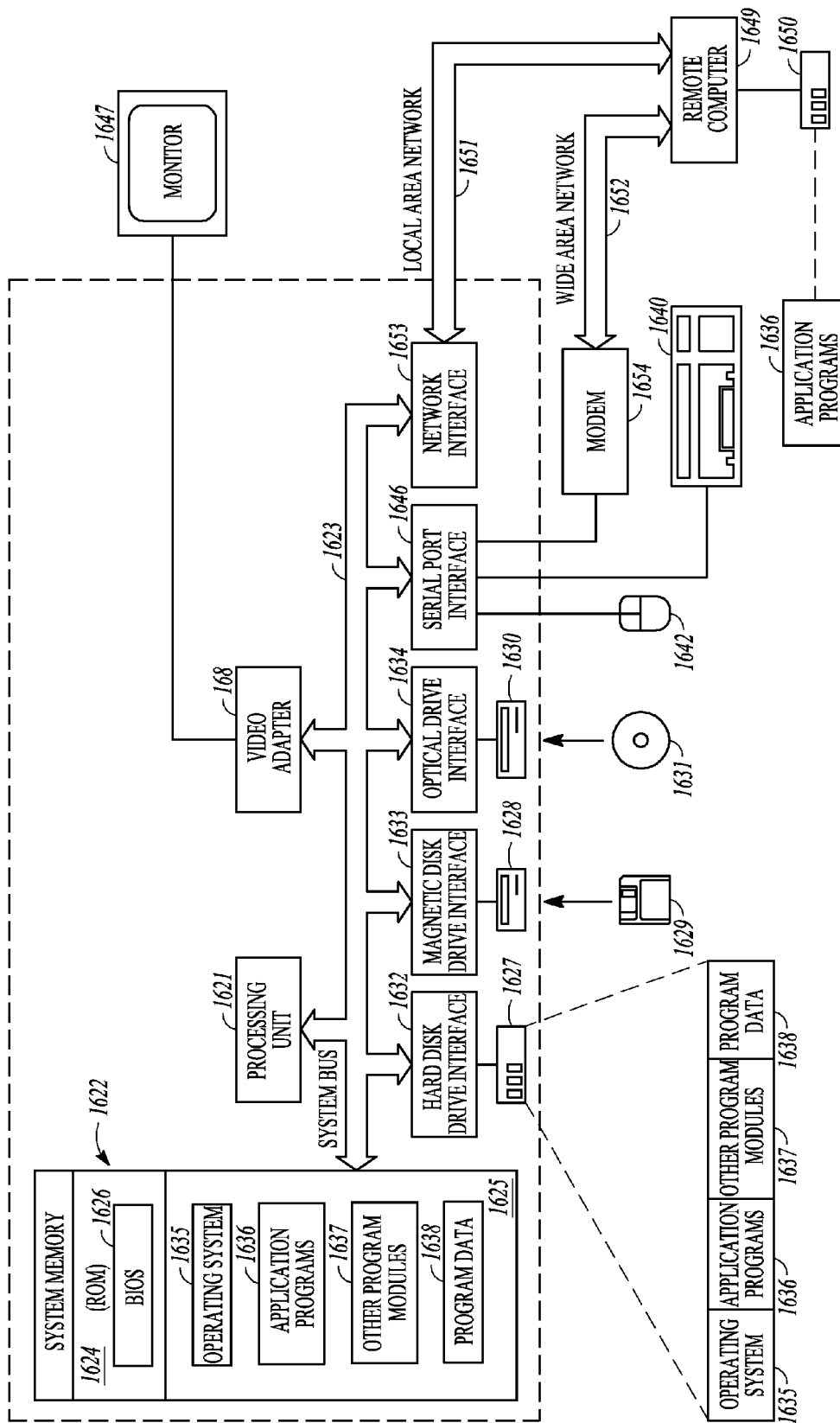


FIG. 16

HYBRID FUEL CELL

RELATED APPLICATION

This application claims priority to U.S. Provisional Application Ser. No. 61/285,479 (entitled Hybrid Fuel Cell, filed Dec. 10, 2009) which is incorporated herein by reference.

BACKGROUND

Efficient energy storage and utilization faces many obstacles. Proton exchange membrane (PEM) fuel cells for man-portable power and micro air vehicles require light-weight, small-size, and high-rate hydrogen sources. Commercially available hydrogen sources such as metal hydrides, compressed hydrogen in cylinders, or catalytic waterborohydride hydrogen generators are capable of high rate hydrogen generation, but are heavy and bulky.

While some hydrogen generators are light-weight and have small size, they are incapable of generating hydrogen at a sufficiently high rate for many applications.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a schematic diagram of a power generator controlling airflow a fuel cell stack and hydrogen generator according to an example embodiment.

FIG. 2 is a block cross section diagram of a hydrogen generator according to an example embodiment.

FIG. 3 is a block cross section diagram part of an end of the hydrogen generator of FIG. 2.

FIG. 4 is perspective view of a hydrogen fuel pellet formed in accordance with an example embodiment.

FIG. 5A is a block perspective diagram of a fuel cell stack according to an example embodiment.

FIG. 5B is a block perspective diagram of the fuel cell stack of FIG. 5A, rotated to illustrate conductive tabs of electrode layers according to an example embodiment.

FIG. 6 is a block cross section diagram illustrating selected layers of the fuel cell stack of FIG. 5A.

FIG. 7 is a perspective view of an oxygen flow channel for the fuel cell stack of FIG. 5A.

FIG. 8 is a perspective view of an electrode layer for the fuel cell stack of FIG. 5A.

FIG. 9 is a perspective view of a gas diffusion layer for the fuel cell stack of FIG. 5A.

FIG. 10 is a perspective view of an adhesive layer for the fuel cell stack of FIG. 5A.

FIG. 11 is a perspective view of an MEA layer for the fuel cell stack of FIG. 5A.

FIG. 12 is a perspective view of a hydrogen flow channel for the fuel cell stack of FIG. 5A.

FIG. 13 is a cross section diagram of a hydrogen fuel cell based power generator according to an example embodiment.

FIG. 14 is a perspective view of the generator of FIG. 13.

FIG. 15 is a flow diagram illustrating control of a hydrogen fuel cell based power generator according to an example embodiment.

FIG. 16 is a block diagram of a specifically programmed system for executing control methods for a hydrogen fuel cell based power generator according to an example embodiment.

DETAILED DESCRIPTION

In the following description, reference is made to the accompanying drawings that form a part hereof, and in which is shown by way of illustration specific embodiments which

may be practiced. These embodiments are described in sufficient detail to enable those skilled in the art to practice the invention, and it is to be understood that other embodiments may be utilized and that structural, logical and electrical changes may be made without departing from the scope of the present invention. The following description of example embodiments is, therefore, not to be taken in a limited sense, and the scope of the present invention is defined by the appended claims.

A hybrid fuel cell power generator provides run time improvement and energy efficiency under specified load power profiles. Moreover, the hybrid fuel cell power generator may be substantially lighter than prior energy storage devices and may have lower projected lifecycle costs, without compromising operation temperature range or environmental and safety performance. A revolutionary improvement in runtime lies in the innovative fuel-cell technology and its fuel chemistry based on lithium aluminum hydride (LAH) that requires no net water consumption in order to sustain its operation, thus eliminating the need for a water fuel reservoir, which enables the energy source to be substantially smaller and lighter than other conventional chemical hydride or direct methanol fuel cells with on-board storage of water (fuel, diluent, or solvent).

A hybrid fuel cell power generator is illustrated at 100 in schematic form in FIG. 1. In one embodiment power generator 100 is a hybridization between a fuel cell 110 that provides maximum energy-density, and power management circuitry 115 utilizing an ultra-high-power rechargeable battery 120, such as a Li-ion battery manufactured by Saft America Inc., that is capable of handling various load power profiles with significant transient fluctuations. Other rechargeable batteries may be used in further embodiments.

The hybrid fuel cell power generator 100 has a system configuration (implemented in a X590 form factor battery package in one embodiment) and operating principle are schematically depicted in FIG. 1. The hybrid fuel cell power generator system 100 includes a hydrogen generator 125. Hydrogen generator 125 in one embodiment is a replaceable and disposable "fuel-cartridge" unit that generates H₂ for a H₂/oxygen proton exchange membrane (PEM) fuel cell 110, and a permanent unit that in one embodiment includes (PEM) fuel cell 110, Li-ion recharge battery 120 as an output stage to interface with an external load, and the power management module 115 that controls electronic and fluidic control circuits (control valves and fan) to dynamically sense and optimize the power generator 100 under varying load and environmental conditions.

The hybrid fuel cell power generator 100 in various embodiment may include one or more of the following innovative aspects:

Hybridization between a fuel cell and Li-ion rechargeable batteries maximizes total energy and extraction efficiency to meet load power profiles with transients (up to 1200 W)

Ultra high power lithium-ion rechargeable batteries developed by Saft with 2× energy density of state-of-the-art (SOA) lithium-ion and peak power >1200 W, enabling >99% power management efficiency

Water-less fuel cell operation scavenges water in vapor form from its cathode and uses it as fuel in the H₂ generation process, enabling >5.3× runtime and 33% less weight of a BA5590 lithium battery:

High fuel energy density (>3100 Whr/liter) and specific energy (>3300 Whr/kg)

Broad environmental operating (−40 to 85° C.) and storage (−40 to 120° C.) range

LAH-based fuel chemistry (water-vapor driven reaction), and engineered fuel formulation (particle size and porosity) enabling >95% fuel utilization at high power Carbon foam and metalized polymer film fuel cell stack composition enabling fast startup and transient response, compact size, and light weight, low internal/contact resistance

Replaceable and disposable fuel-cartridge configuration enabling further enhanced runtime and weight advantages (7.1× runtime and 58% weight reduction in a volume equivalent to two BA5590 batteries) for extended mission duration and reduced life-cycle cost

Hot-swappable fuel cartridges for uninterrupted power

Ambient air serves as the hybrid fuel cell power generator 100 oxygen source, carrier gas for the water vapor fuel, and coolant gas for the fuel cell stack and H2 generator. A miniature fan 130 draws in fresh air from ambient via an inlet 135, circulates it over the fuel cell stack via an ambient air passage 140 and H2 generator via path 145, and exhausts to ambient at outlet 150. As the air passes through the fuel cell stack, oxygen is consumed by the fuel cell, and water vapor and waste heat are absorbed. This air (now primarily nitrogen and water vapor) travels to the H2 generator via passages 140 and 145 and passes over the surface of hydrogen producing fuel, which in one embodiment may include a bundle of fuel rods or a fuel with humid air passages in various embodiments.

The fuel rods in one embodiment consist of thin-wall sulfonated tetrafluoroethylene (STFE) polymer tubes with a porous LAH core. The STFE tubes are highly permeable to water vapor but relatively impermeable to other gases (O₂, N₂, H₂, etc). The tubes may be cylindrical or partly conical in shape in some embodiments. The cross section of the tubes may also be polygonal in further embodiments. The LAH in the fuel rod core is highly reactive to water vapor and spontaneously generates H₂ gas (and heat) upon exposure, creating a low humidity environment inside the fuel rod core. Water vapor in the air stream permeates the STFE tubes due to the large concentration gradient across the tube wall, and once inside the tube, reacts with LAH to generate H₂. The H₂ is trapped inside the STFE tubes and is collected and fed through a manifold 155 and passage 160 to an anode of the fuel cell stack 110, where it is consumed to generate electrical power, heat, and water.

As the air passes through the H2 generator, it also absorbs waste heat from the fuel rods before exhausting to ambient at outlet 150. The electrical power generated in the fuel cell stack may be fed to power management circuitry which conditions the power and provides it to the load. A suite of sensors, represented in various example positions at 165, 166, and 167 monitor temperature, humidity, and pressure throughout the system 100. Data provided by the sensors, as well as the electrical load and charge state of the Li-ion rechargeable batteries 120 are used by the control electronics 115 to determine and set the fan 130 speed and control valve positions.

In one embodiment, an ambient air in control valve is located in passage 140 between the fuel cell 110 and the fan 130. Control valve 170 may be used to control addition of ambient air into the flow path via an inlet 175. A second control valve 180 may be located in passage 145 between the fan 130 and hydrogen generator 125 to vent excess gas and water vapor prior to it causing hydrogen generation.

Fuel consumption may also be monitored, and the remaining capacity may be displayed on the hybrid fuel cell power generator packaging in various embodiments. In one embodiment, greater than 95% fuel utilization may be achieved through optimized LAH fuel formation (porosity, particle

size/distribution). The STFE tube composition, geometry, fuel rod packing configuration, and airflow control may be further optimized to achieve a H₂ generation rate sufficient for 50 W in one embodiment. Further embodiments may provide from 10 W to more than 1000 W of power.

In some embodiments, the LAH-water reaction generates a substantial amount of heat (150 kJ/mol LAH, exothermic) leading to a rise in temperature in the fuel. The temperature may be monitored along with controlling airflow over the stack to maintain temp below 125° C. In other words, as the temperature rises, more air may be brought in via inlet 175 to cool the air provided to the fuel via passage 145. Similarly, less air may be added as the temperature of the fuel decreases.

Li₂CO₃ may form in the presence of atmospheric CO₂ if the local relative humidity is greater than 10-15%. Li₂CO₃ formation may be prevented by: 1) controlling the humidity in the fuel rods to <15% by setting fan speed and modulating valve positions such that water is exhausted at control valve 180, and 2) engineering the fuel formulation (particle size/distribution and porosity) to maintain a small humidity gradient in the fuel rods.

Electrochemical system power performance can substantially degrade at low temperatures (−40° C.) due to slower reaction kinetics and lower electrolyte conductivity. The hybrid fuel cell may avoid freezing problems by 1) using water in vapor form, 2) adjusting airflow to prevent water vapor condensation, and 3) using heat generated by the fuel cell stack and H2 generator to regulate the temperature of the fuel cell stack and fuel rods.

Fuel cells and other open (air breathing) systems like metal-air batteries face unique environmental challenges related to ambient humidity, unlike closed (sealed) systems (BA5590/BB2590) that operate essentially independent of ambient humidity. Open systems face flooding at high ambient humidity and dry out at low ambient humidity, both of which limit power output. Various embodiments of the hybrid fuel cell based generator utilize a variable speed fan and modulating valves to control the humidity throughout the system, ensuring that the fuel cell stack and H2 generator each have the optimum water concentration and flow rate.

Fuel cell stack: Fuel cell electrochemistry, heat and water generation, H₂ and oxygen consumption, fluidic and thermal resistance in flow channels, current and potential (I-V), over temperature and humidity may be determined and control based on calculations or experiment in various embodiments.

Hydrogen generator: LAH-water vapor reaction chemistry, water vapor consumption and H₂ generation, fluidic and thermal resistance in fuel rods and flow channels, water vapor permeability of STFE tubing, mass transfer (diffusion) resistance in fuel rod, reaction product expansion, fuel utilization, over temperature and humidity: The H2 generator's fuel utilization may be determined based on calculations or experiment in various embodiments.

Fluidic circuitry: Appropriate sizing of fan and control valves may be based on fluidic resistance of the fuel cell stack, H2 generator, and flow channels, power consumption of the fan and control valves, heat transfer in fluidic circuitry and effects on water vapor condensation and required flow over temperature and humidity. In one embodiment, the outlet of the H2 generator is sized consistent with the area of the fluid flow path through the H2 generator to ensure no further resistance to flow is created at the outlet. In further embodiments, the outlet may be sized based on further considerations.

Power consumption of the microcontroller and sensors, and efficiency of power management circuitry may also be taken into account. Capacity, charge/discharge rate, and effi-

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ciency of Li-ion rechargeable batteries may be adjusted based on the desired maximum power output of the generator.

In some embodiments, noryl plastic packaging consistent with the type used on the Saft BA5590 may be used. Many different types of plastics and other materials that provide low weight yet sufficient tolerance to the operating parameters and environmental conditions of the generator may be used. The projected fuel efficiency, runtime, and energy of various hybrid fuel cell (HFC) generators compared to the BA5590 and BB2590 are shown for each load profile in Table-1. Three different load profiles are illustrated for conditions consisting of 22° C. and 50% relative humidity of ambient air. In the #2 load profile the negative power pulse is not absorbed by BA5590.

TABLE 1

Load Profile	BA5590		BB2590		HFC					
	Avg Power (W)	Energy (Whr)	Run time (hrs)	Energy (Whr)	Run time (hrs)	Energy (Whr)	Run time (hrs)	Efficiency (%)	Run time (X) over BA5590	Run time (X) over BB2590
1	33	204	6.2	211	6.4	1125	34.1	91.2	5.5	5.3
2	21.75 (38)*	201	5.3	209	9.6	1256	57.8	102	11.0	6.0
3	31	207	6.7	213	6.9	1144	36.9	92.8	5.5	5.4

As shown in the right-most two columns of Table-1, the projected x590 hybrid fuel cell power generator **100** runtime advantages over that of BA5590 and B2590 are between 5.3× and 11×, providing a significant increase in available energy for the soldier. The larger 11× runtime advantage of hybrid fuel cell power generator **100** over BA5590 for load profile **2** results from the fact that BA5590 does not absorb the negative portion of the power profile. The fuel efficiency of the hybrid fuel cell power generator **100** is greater than 91% for all load profiles, and is greater than 100% for the second load profile. Fuel efficiency in this context may be defined as the ratio of net electrical energy delivered to the load to theoretical energy in the LAH plus that in the Li-ion batteries. The theoretical energy in the chemical hydride fuel is defined as the energy available assuming complete (100%) stoichiometric conversion of LAH to H₂ (i.e. 1 mol of LAH generates 4 mol of H₂), and 50% H₂-to-electrical conversion efficiency in the fuel cell (i.e. the fuel cell operates at ~0.6 V/cell). This operating point is selected because the fuel cell stack is designed to operate at 0.6 V/cell at a power level of 33 W. This definition allows for greater than 100% efficiency if the FC is operating at less than 33 W (i.e. the cell potential is >0.6 V/cell).

The mass, volume, energy, and power consumption of the components comprising the preliminary hybrid fuel cell power generator **100** system are shown in Table 2. LAH fuel cartridge comprises 59% and 54% of the system volume and mass, respectively, which determines a gross energy capacity (before efficiency and parasitic power) of 1233 Whr. The hybrid fuel cell power generator **100** is tightly integrated, with over 95% of the X590 volume occupied by system components. The design also allocates generous 110 cc and 85 cc (14% and 11% of the total volume) to “FC stack” and “fluidic circuits”, respectively. Obviously, any volume reduction (or increase) in the non-energy storing components can potentially translate into gain (or loss) in energy capacity or runtime. The “parasitic” power consumption for Load Profile **1** is 1.3 W, or 3.9% of the 33 W average power delivered to the load. It is similarly low for the other two load profiles.

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TABLE 2

Sub System	Mass (g)	% Mass	Volume (cc)	% Volume	Energy (Whr)	Power consumption (W)
Fuel Cell Stack	38	5.7	100	11.9	0	0
Power/control electronics	15	2.3	18	2.1	0	0.26
Li-ion rechargeable battery	62	9.4	54	6.4	19	0
Fluidic circuitry	64	9.7	85	10.1	0	1.04

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TABLE 2-continued

Sub System	Mass (g)	% Mass	Volume (cc)	% Volume	Energy (Whr)	Power consumption (W)
LAH Fuel Cartridge	471	71.1	579	68.8	1214	0
Case	48	7.3	45	5.4	0	0
Total	662	100	841	100	1233	1.3

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FIG. 2 is a block cross section diagram of a hydrogen generator **200** according to an example embodiment. Hydrogen generator **200** in one embodiment is a high-rate hydrogen generator suitable for man-portable power and micro air vehicle applications that provides 4-5× the hydrogen of commercially available hydrogen sources of the same size and weight. Many different hydrogen producing fuels, such as LAH may be used. In further embodiments, the hydrogen producing fuel may include LiAlH₄, NaAlH₄, KAlH₄, MgAlH₄, CaH₂, LiBH₄, NaBH₄, LiH, MgH₂, Li₃Al₂, CaAl₂H₈, Mg₂Al₃, alkali metals, alkaline earth metals, alkali metal silicides, or any combinations thereof.

In one embodiment, the hydrogen generator **200** consists of a bundle of sulfonated tetrafluoroethylene (STFE) tubes **210** spaced substantially uniformly in a block of a porous and water-reactive fuel (chemical hydride) **215**. In further embodiments, the tubes may be formed of a hydrogen permeable material, such as a polymer. Nafion® material may be used in one embodiment. The tubes may have wall shapes similar to those described above. Note that this embodiment is different from the fuel described above, where the fuel was disposed inside the tubes with water vapor passed on the outside of the tubes. In generator **200**, the tubes **210** and fuel **215** are enclosed in a particulate filter **217** and further enclosed in a gas-impermeable container **220** with an inlet **225** and outlet **230** that provide a flow path indicated by arrows **235** for humidified air through the center of the STFE tubes **210**, and a separate outlet **240** from the chemical hydride block of fuel **215** for hydrogen gas. The outlet **240** is sized to handle a maximum flow rate of hydrogen without creating substantial back pressure.

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Water vapor from the air selectively permeates the STFE tubing **210** into the fuel block **215**, while the other gases in air remain in the tubes **210** and are exhausted to ambient. The water vapor permeates the tubes **210** due to a large concentration gradient between the air and fuel sides of the tubes **210**. In one embodiment, water in liquid form is to be avoided, as it may contain ions that would damage the tubing and prevent further water vapor permeation.

Once inside the fuel block **215**, the water vapor reacts with the chemical hydride and generates hydrogen. The hydrogen diffuses throughout the fuel block **215** to outlet **240**, where it may be fed to a PEM fuel cell as illustrated in FIG. **1** to generate electrical power. The tubes in one embodiment are substantially uniformly spaced to permit the water vapor to permeate the fuel as the hydrogen is released, such that substantially all of the hydrogen in the fuel is released over time. The STFE tubing **210** in one embodiment is a highly effective selectively permeable membrane that traps air on the inside, and keeps hydrogen on the outside and effectively only allows water vapor to pass through. The sizes of the inlet and outlet are formed to match or exceed the cross section of the tubes.

The hydrogen generator **200** interfaces with a fuel cell system, and may be contained in a replaceable and disposable (recyclable) cartridge such as container **220**. These cartridges may provide a low-cost source of energy having a dramatic improvement in energy versus prior batteries and fuel cell systems in part, because the fuel cell system is retained, while only the cartridge is replaced. The hydrogen generator **200** may be cylindrical in geometry in one embodiment having an axis that is substantially parallel to the tubes.

FIG. **3** is a block cross section diagram part of an end of the hydrogen generator of FIG. **2** providing further details of the assembly of the power generator **200**. FIG. **3** illustrates in further detail that the STFE tubes **210** may be held in place and sealed at the top and bottom with o-rings **310**, **315** and squeezed together by two plates **320**, **325**. Plates **320**, **324** are formed with holes corresponding to the locations of the tubes and fit over the respective ends of the tubes. The perimeter of the plates are formed to mate with the inner perimeter of the container **220** and form a seal against corresponding ledges **245**, **250** with the o-rings **255**, **260** as illustrated in FIG. **2** and shown in further detail in FIG. **3**.

The fuel block **215** may be formed utilizing a custom die having rods corresponding to the desired tube locations and inner dimensions corresponding to the dimensions of the container **220**. A chemical hydride powder of a certain particle size is pressed in the die to a desired density with the cylindrical holes for the STFE tubes. A plate with holes corresponding to the tubes may be used to press the fuel into the die. A resulting porosity of the pressed fuel is about 20% in one embodiment, allowing hydrogen to flow freely through the block.

The resulting pressed fuel block **215**, illustrated in FIG. **4** at **400** is placed in the container **220**, and the STFE tubes **215** are inserted into the block **400** and secured at top and bottom with the o-rings and the plates. Caps with the inlet **225** and outlet **230** and also with o-ring seals **265** may be threaded onto the ends of the housing. Hydrogen is fed out of the hydrogen generator through port **240** in the side of container **220**. A particulate filter **410** surrounds the fuel block and prevents particles from escaping from the port in the side. The particulate filter also provides a flow path from the perimeter of the pellet to the hydrogen port. In one embodiment, the filter also covers the ends of the fuel block, with openings for insertion of the tubes.

FIG. **5A** is a block perspective diagram of a fuel cell stack **500** according to an example embodiment. FIG. **5B** is a block

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perspective diagram of the fuel cell stack **500** of FIG. **5A**, rotated to illustrate conductive tabs of electrode layers according to an example embodiment. Further diagrams are shown to illustrate details of various layers in the stack **500**. The stack is formed with gas flow layers to facilitate flow of hydrogen and oxygen in air past fuel cell layers to facilitate the reaction producing electricity. In one embodiment, hydrogen flow layers are indicated at **510**, and oxygen flow layers are indicated at **520**. There are 10 layers of each, with fuel cell layers located between adjacent flow layers, resulting in 20 electricity producing fuel cell layers. In one embodiment, each layer has four fuel cells coupled in series to produce approximately 2.4 volts per layer under load. The layers are then selectively coupled in series via conductive tabs indicated at **530** and **540** to produce an output voltage of 48 volts under load in one embodiment. To make it easier to couple in series, alternate layers may be flipped, with negative tabs coupled to positive tabs and positive tabs coupled to negative tabs in an alternating manner down the stack. In further embodiments, the tabs may be coupled differently to provide different desired voltage and current levels, and more or fewer total layers may also be used. Still further, the number of cells per layer as well as the manner in which they are connected may be modified to provide further flexibility in providing a power generator with desired current-voltage characteristics.

In some embodiments, manifolds are provided on sides of the fuel cell stack to deliver oxygen and hydrogen to the corresponding layers. The outside of the fuel cell stack may be encapsulated with a gas impermeable layer to ensure separation of the oxygen and hydrogen flow paths to and from the gas flow layers.

FIG. **6** is a block cross section diagram illustrating selected layers of the fuel cell stack of FIG. **5A**. Starting to the top of the selected layers and oxygen flow channel **610** is shown. A cathode electrode **615** is adjacent the flow channel **610**, followed by a gas diffusion layer **620** adapted to correspond to each of the cells, with an adhesive layer **630**. A membrane electrode assembly layer **640** is then disposed to receive oxygen from the flow channel **610**, which is porous, and through the gas diffusion layer **630** on a first side. Hydrogen from a hydrogen flow channel **645** on the other side of the membrane electrode assembly layer **640** passes through an anode electrode layer **645**, and gas diffusion layer **650** adhered between the membrane electrode assembly layer **640** and gas diffusion layer **650** by an adhesive layer **655**. The hydrogen and oxygen react at the membrane electrode assembly layer **640** to produce electricity, which is conducted by the anode and cathode electrode layers. The layers between the flow channels are flipped and repeated between succeeding flow channels that alternate between hydrogen and oxygen flow channels.

FIG. **7** is a perspective view of an oxygen flow channel layer **610** for the fuel cell stack of FIG. **5A**. The oxygen flow channel **610** has a number of holes which may be parallel passages to facilitate the flow of oxygen contained in air. In one embodiment, the flow channel layer **610** is formed of carbon foam that is permeable to the flow of oxygen to facilitate flow of oxygen transfer to the layer to reach the membrane electrode assembly layer **640**. In further embodiments different lightweight porous materials may be used that are compatible with oxygen.

FIG. **8** is a perspective view of an electrode layer **800** for the fuel cell stack of FIG. **5A**. The layout may be the same for both anode and cathode electrode layers. An electrode tab **810** is coupled to electrode areas **820** corresponding to the membrane electrode assembly layer cell areas. The electrode areas

may be coupled in series as described above, and may be formed of thin layer of gold or other conductor in various embodiments.

FIG. 9 is a perspective view of a gas diffusion layer **900** for the fuel cell stack of FIG. 5A. The gas diffusion layer may be same on both sides of the membrane electrode assembly layer **640** in one embodiment. The gas diffusion layer provides good permeability to gas and forms a low resistance electrical connection between the electrode and the MEA.

FIG. 10 is a perspective view of an adhesive layer **1000** for the fuel cell stack of FIG. 5A. The adhesive layer **1000** has opening corresponding to the cell areas in the membrane electrode assembly layer **640** to allow passage of the oxygen and hydrogen to the respective sides of the membrane electrode assembly layer **640**.

FIG. 11 is a perspective view of a membrane electrode assembly layer **640** for the fuel cell stack of FIG. 5A. The cell areas are defined by the openings in the adhesive layers and the corresponding electrode areas.

FIG. 12 is a perspective view of a hydrogen flow channel **645** for the fuel cell stack of FIG. 5A. The hydrogen flow channel **645** has a number of holes which may be parallel passages to facilitate the flow of hydrogen contained in air. In one embodiment, the flow channel layer **645** is formed of carbon foam that is permeable to the flow of hydrogen to facilitate flow of hydrogen transfer to the layer to reach the membrane electrode assembly layer **640**. In further embodiments different lightweight porous materials may be used that are compatible with hydrogen.

FIG. 13 is a cross section diagram of a hydrogen fuel cell based power generator **1300** according to an example embodiment. This diagram illustrates an example layout for the power generator, illustrating component placement and airflow. Electrical connections are not shown for simplicity. Power management circuitry **1310** and batteries **1315** are shown in the upper left quadrant of the diagram, with a replaceable fuel cartridge **1320** shown in the bottom half of the generator **1300**. The fuel cell stack **1325** is shown above the cartridge **1320** with an ambient air inlet indicated at **1330** coupled to the stack via a manifold that is not shown. The air inlet **1330** is the beginning of a flow path that provides oxygen to the fuel cell stack **1325** and then continues on through a first valve **1335** with air inlet **1340**, a fan **1345**, and a second valve **1350** with air outlet **1355**. The flow path then continues on to the fuel cartridge **1320** and is exhausted at air outlet **1360**. Not illustrated is a hydrogen outlet coupled via a manifold to the fuel cell stack **1325**.

FIG. 14 is a perspective partially transparent view of the power generator **1300**, showing fuel containing STFE tubes.

FIG. 15 is a flow diagram **1500** illustrating control of a hydrogen fuel cell based power generator according to an example embodiment. In one embodiment, the power management and controller **115** executes functions to control both the humidity level of gas fed to the hydrogen generator and the temperature of the airflow as a function of the information obtained from the various sensors. In general, for each kilowatt of electricity generated by the fuel cell stack, 1 kilowatt of heat may be generated. Further, the generation of hydrogen also results in an additional 1 kilowatt of heat. The controller **115** is used to remove excess heat by controlling fans and valves. In further embodiments, the controller **115** also controls the fans and valves to ensure a desired amount of water vapor is provided to the hydrogen generator to satisfy demand.

Controller **115** may also control the fan and valves to regulate the amount of ambient air run past the fuel cell stack. By controller the amount of fluid flow in the air path via the

control valve **175**, more or less ambient air may be drawn in through inlet **140** and past the fuel cell stack. The amount of oxygen in the air drawn in is not a limiting factor in the performance of the fuel cell stack, so the effect of controlling the airflow is mainly maintaining a temperature and humidity of the fuel cell stack in a desired range.

At **1510**, the controller **115** obtains data from numerous sensors regarding the temperature, humidity, and load. At **1520**, the signals are generated to control valve **170** to control the amount of ambient air that can be added to the airflow. If the temperature of the fuel cell stack is high, more air can be drawn in through inlet **140** and used to cool the fuel cell stack. The fan speed can also be increased to help cool the fuel cell stack. At **1530**, the controller **115** controls valve **180** to exhaust air from the flow path. Additional water vapor may be exhausted at this point to reduce the amount of water vapor received by the hydrogen generator. This may be done if the load is requiring less power, or if the water vapor content of flow in the path is otherwise too high. At **1540**, the controller **115** controls the variable speed fan **130** as a function of the power demand and cooling requirements of the power generator. This process continues for as long as the system is operating.

During times of high demand, the power generator produces more hydrogen and uses more water vapor to do so. The power generator also generates more heat. The controller **115** thus increases the airflow by adding more ambient air to the flow path and increasing the speed of the fan. If the ambient humidity is too high, some of the airflow may be vented via valve **180**. During periods of lower power demand, less heat is generated, and less airflow and water vapor are needed. In this case, the fan speed is decreased, and more water vapor may be vented via valve **180**. Since water vapor is recycled in the system in addition to the ability to add further water vapor from ambient, higher amounts of hydrogen may be generated than in either closed systems with a water reservoir, or open systems the utilize only ambient water vapor from the humidity of the ambient air.

In further embodiments, different numbers of fans and valves may be used, such as two fans and one valve, or high numbers of both fans and valves. The combination of fan(s) and valve(s) is sufficient to facilitate independent control of airflow over the fuel cell stack and the amount of flow provided to the hydrogen generator. In one embodiment, the amount of airflow through the fuel cell stack may be optimized separately from the flow to the hydrogen generator.

FIG. 16 is a block diagram of a specifically programmed system for executing control methods for a hydrogen fuel cell based power generator according to an example embodiment. One embodiment of hardware and operating environment of the system includes a general purpose computing device in the form of a computer **1600** (e.g., a personal computer, workstation, or server), including one or more processing units **1621**, a system memory **1622**, and a system bus **1623** that operatively couples various system components including the system memory **1622** to the processing unit **1621**. There may be only one or there may be more than one processing unit **1621**, such that the processor of computer **1600** comprises a single central-processing unit (CPU), or a plurality of processing units, commonly referred to as a multi-processor or parallel-processor environment. In various embodiments, computer **1600** is a conventional computer, a distributed computer, or any other type of computer.

The system bus **1623** can be any of several types of bus structures including a memory bus or memory controller, a peripheral bus, and a local bus using any of a variety of bus architectures. The system memory can also be referred to as

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simply the memory, and, in some embodiments, includes read-only memory (ROM) **1624** and random-access memory (RAM) **1625**. A basic input/output system (BIOS) program **1626**, containing the basic routines that help to transfer information between elements within the computer **1600**, such as during start-up, may be stored in ROM **1624**. The computer **1600** further includes a hard disk drive **1627** for reading from and writing to a hard disk, not shown, a magnetic disk drive **1628** for reading from or writing to a removable magnetic disk **1629**, and an optical disk drive **1630** for reading from or writing to a removable optical disk **1631** such as a CD ROM or other optical media.

The hard disk drive **1627**, magnetic disk drive **1628**, and optical disk drive **1630** couple with a hard disk drive interface **1632**, a magnetic disk drive interface **1633**, and an optical disk drive interface **1634**, respectively. The drives and their associated computer-readable media provide non volatile storage of computer-readable instructions, data structures, program modules and other data for the computer **1600**. It should be appreciated by those skilled in the art that any type of computer-readable media which can store data that is accessible by a computer, such as magnetic cassettes, flash memory cards, digital video disks, Bernoulli cartridges, random access memories (RAMs), read only memories (ROMs), redundant arrays of independent disks (e.g., RAID storage devices) and the like, can be used in the exemplary operating environment.

A plurality of program modules can be stored on the hard disk, magnetic disk **1629**, optical disk **1631**, ROM **1624**, or RAM **1625**, including an operating system **1635**, one or more application programs **1636**, other program modules **1637**, and program data **1638**. Programming for implementing one or more processes or method described herein may be resident on any one or number of these computer-readable media.

A user may enter commands and information into computer **1600** through input devices such as a keyboard **1640** and pointing device **1642**. Other input devices (not shown) can include a microphone, joystick, game pad, satellite dish, scanner, or the like. These other input devices are often connected to the processing unit **1621** through a serial port interface **1646** that is coupled to the system bus **1623**, but can be connected by other interfaces, such as a parallel port, game port, or a universal serial bus (USB). A monitor **1647** or other type of display device can also be connected to the system bus **1623** via an interface, such as a video adapter **1648**. The monitor **1647** can display a graphical user interface for the user. In addition to the monitor **1647**, computers typically include other peripheral output devices (not shown), such as speakers and printers.

The computer **1600** may operate in a networked environment using logical connections to one or more remote computers or servers, such as remote computer **1649**. These logical connections are achieved by a communication device coupled to or a part of the computer **1600**; the invention is not limited to a particular type of communications device. The remote computer **1649** can be another computer, a server, a router, a network PC, a client, a peer device or other common network node, and typically includes many or all of the elements described above I/O relative to the computer **1600**, although only a memory storage device **1650** has been illustrated. The logical connections depicted in FIG. **16** include a local area network (LAN) **1651** and/or a wide area network (WAN) **1652**. Such networking environments are commonplace in office networks, enterprise-wide computer networks, intranets and the internet, which are all types of networks. When used in a LAN-networking environment, the computer **1600** is connected to the LAN **1651** through a network inter-

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face or adapter **1653**, which is one type of communications device. In some embodiments, when used in a WAN-networking environment, the computer **1600** typically includes a modem **1654** (another type of communications device) or any other type of communications device, e.g., a wireless transceiver, for establishing communications over the wide-area network **1652**, such as the internet. The modem **1654**, which may be internal or external, is connected to the system bus **1623** via the serial port interface **1646**. In a networked environment, program modules depicted relative to the computer **1600** can be stored in the remote memory storage device **1650** of remote computer, or server **1649**. It is appreciated that the network connections shown are exemplary and other means of, and communications devices for, establishing a communications link between the computers may be used including hybrid fiber-coax connections, T1-T3 lines, DSL's, OC-3 and/or OC-12, TCP/IP, microwave, wireless application protocol, and any other electronic media through any suitable switches, routers, outlets and power lines, as the same are known and understood by one of ordinary skill in the art.

The Abstract is provided to comply with 37 C.F.R. §1.72(b) is submitted with the understanding that it will not be used to interpret or limit the scope or meaning of the claims.

The invention claimed is:

1. A power generator comprising:

a fuel cell stack;

a gas flow loop having an input of oxygen containing ambient air and flowing through the fuel cell stack to provide oxygen containing air to the fuel cell stack and to provide a carrier gas to cool and remove water from the fuel cell stack, the gas flow loop including a temperature sensor and a humidity sensor;

a hydrogen generator coupled to the gas flow loop to receive water vapor from ambient air introduced into the gas flow loop and water vapor generated by the fuel cell stack and to provide hydrogen to the fuel cell stack; and a controller coupled to the gas flow loop to separately control airflow past the fuel cell stack based on temperature information received from the temperature sensor and control water vapor provided to the hydrogen generator based on humidity information received from the humidity sensor.

2. The power generator of claim 1 and further comprising a variable speed fan disposed in the gas flow loop and controlled by the controller.

3. The power generator of claim 2 and further comprising: a first air inlet in the gas flow loop upstream of the fuel cell stack;

a second air inlet in the gas flow loop downstream of the fuel cell stack; and

an air outlet in the gas flow loop disposed between the fan and the hydrogen generator, wherein the fan is downstream of the second air inlet.

4. The power generator of claim 3 wherein the second air inlet and the air outlet each have a corresponding controller controlled valve.

5. The power generator of claim 4 wherein the controller controls the temperature of the hydrogen generator via the fan and valves.

6. The power generator of claim 4, wherein the controller separately controls airflow and water vapor by controlling the variable speed fan, the second air inlet valve, and the air outlet valve, the controller controlling the airflow and water vapor using data representative of an electrical load and charge state of the rechargeable battery.

7. The power generator of claim 1 wherein the fuel cell stack comprises multiple fuel cell layers disposed between alternating hydrogen and oxygen flow channel layers.

8. The power generator of claim 7 wherein the flow channel layers are formed of a light weight porous, high strength material. 5

9. The power generator of claim 8 wherein the flow channel layers are formed of carbon foam.

10. The power generator of claim 1 wherein the hydrogen generator comprises lithium aluminum hydride. 10

11. The power generator of claim 1 wherein the hydrogen generator includes at least one chemical hydride selected from the group consisting of LiAlH_4 , NaAlH_4 , KAlH_4 , MgAlH_4 , CaH_2 , LiBH_4 , NaBH_4 , LiH , MgH_2 , Li_3Al_2 , CaAl_2H_8 , Mg_2Al_3 , alkali metals, alkaline earth metals, and alkali metal silicides. 15

12. The power generator of claim 1 wherein the hydrogen generator includes multiple tubes formed of water vapor permeable and hydrogen impermeable material to separate a hydrogen producing fuel from the gas flow loop. 20

13. The power generator of claim 12 wherein the water vapor permeable and hydrogen impermeable material comprises sulfonated tetrafluoroethylene (STFE).

14. The power generator of claim 1 wherein the hydrogen generator comprises a replaceable cartridge. 25

15. The power generator of claim 1 and further comprising a rechargeable battery electrically coupled to the fuel cell stack.

16. The power generator of claim 15 wherein the rechargeable battery comprises a lithium-ion rechargeable battery. 30

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